

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000057**Date Inspected:** 09-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Huang Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bid 52, 55 Tower and Girder**Summary of Items Observed:**

Office of Structural Materials Quality Assurance Inspector (QA), Mark Wright was present as requested to observe quality control functions related to procedure qualification record (PQR) testing at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

The QA Inspector observed the continuation welding of a Procedure Qualification (PQR) test plate identified as HP-2006116. The HP2006116 test was conducted on A709-50-2 steel using Flux Cored Arc Welding (FCAW); Hyundai Super cored 71H, 1.4mm diameter electrode in the 1G (flat) position with a root opening of 6mm to AWS D1.5, Section 5.13 (non-standard) with a ceramic backing. The QA Inspector observed ZPMC Quality Control (QC) recording the essential variable (amps, volts, travel speed) for each pass and randomly verified the parameters using an Amprobe® amperage / voltage meter and a stopwatch. The welding appeared to comply with the contract documents.

The QA Inspector issued a lot number of B41-005-07 for this PQR. See TL-6032 for details of this test.

The QA Inspector also observed the completion of PQR HP2006117-2 on this date. Lot number B41-007-07 was issued for this PQR.

The QA Inspector observed a fillet weld soundness test performed using E71T1 wire to weld a T-joint of A709HPS485W steel. The supporting PQR for this test is HP2006120. Lot number B41-006-07 was issued for this PQR.

**Summary of Conversations:**

See Task Leader journal for this date.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Wright,Mark	Quality Assurance Inspector
<b>Reviewed By:</b>	McClary,David	QA Reviewer

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